



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RB T102137-107-107
Job Sheet 196200



Part No: RB T102137-107-107

Job Qty: 10 pcs

Part Name: Sleeve



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/7/19

Job Tracking No:

Due Date: 6/20/19

Created By: Jennifer Renwick

Type: SOLD

Description:

Note: DWG RB T102137-107 RevG IPP Rev A 17.12.07 New issue DP Verify DD/IPP Rev. B 19.06.07 Material change DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
110	SL-154 - 1	10 pcs	6/20/19	6/20/19	1.00	0.50	SL-154 - 1	JB 19-06-11
120	QC 2	10 pcs	6/20/19	6/20/19	0.00	0.00	QC 2 - 1	
							QC 2 - 12	
							QC 2 - 14	
							QC 2 - 17	
							QC 2 - 19	
							QC 2 - 2	
							QC 2 - 20	
							QC 2 - 22	
							QC 2 - 23	
							QC 2 - 25	
							QC 2 - 32	
							QC 2 - 33	
							QC 2 - 35	
							QC 2 - 39	
							QC 2 - 4	
							QC 2 - 40	
							QC 2 - 44	
							QC 2 - 45	
							QC 2 - 48	
							QC 2 - 49	
							QC 2 - 50	
							QC 2 - 51	
							QC 2 - 52	
							QC 2 - 57	
							QC 2 - 62	JB 19-06-11
							QC 2 - 63	
							QC 2 - 8	
							QC 2 - 66	
							QC 2 - 64	
							QC 2 - 65	
							QC 2 - 5	
							QC 2 - 71	
							QC 2 - 73	
							QC 2 - 69	
130	QC 8	10 pcs	6/20/19	6/20/19	0.00	0.00	QC 8 - 12	
							QC 8 - 14	
							QC 8 - 17	
							QC 8 - 20	
							QC 8 - 25	
							QC 8 - 3	

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com



Container No: S189184

Part: RB T102137-107-107
Job No: 196200

Serial No/Batch: S189184

Revision: G

Inspector:

Exp Date:

DAS
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9-89

DAS
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9-89

				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	D.A. 19-06-12
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
131 QC 5	10 pcs	6/20/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	DAS
				QC 5 - 30	40
				QC 5 - 40	JUN 12 2019 9-89
132 Outsource - 1 - Heat Treat	10 pcs	6/20/19		MEI001-VC	12 JUN 2019-06-14
133 Packaging 2-1 - Receive - B4B	10 pcs	6/20/19	0.00 0.00	Packaging 2 - 1 - B4B	
				Packaging 2 - 2 - B4B	
				Packaging 2 - 3 - B4B	
				Packaging 2 - 5 - B4B	
				Packaging 2 - 4 - B4B	
				Packaging 2 - 6 - B4B	
				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	OP JUL 03 2019
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	

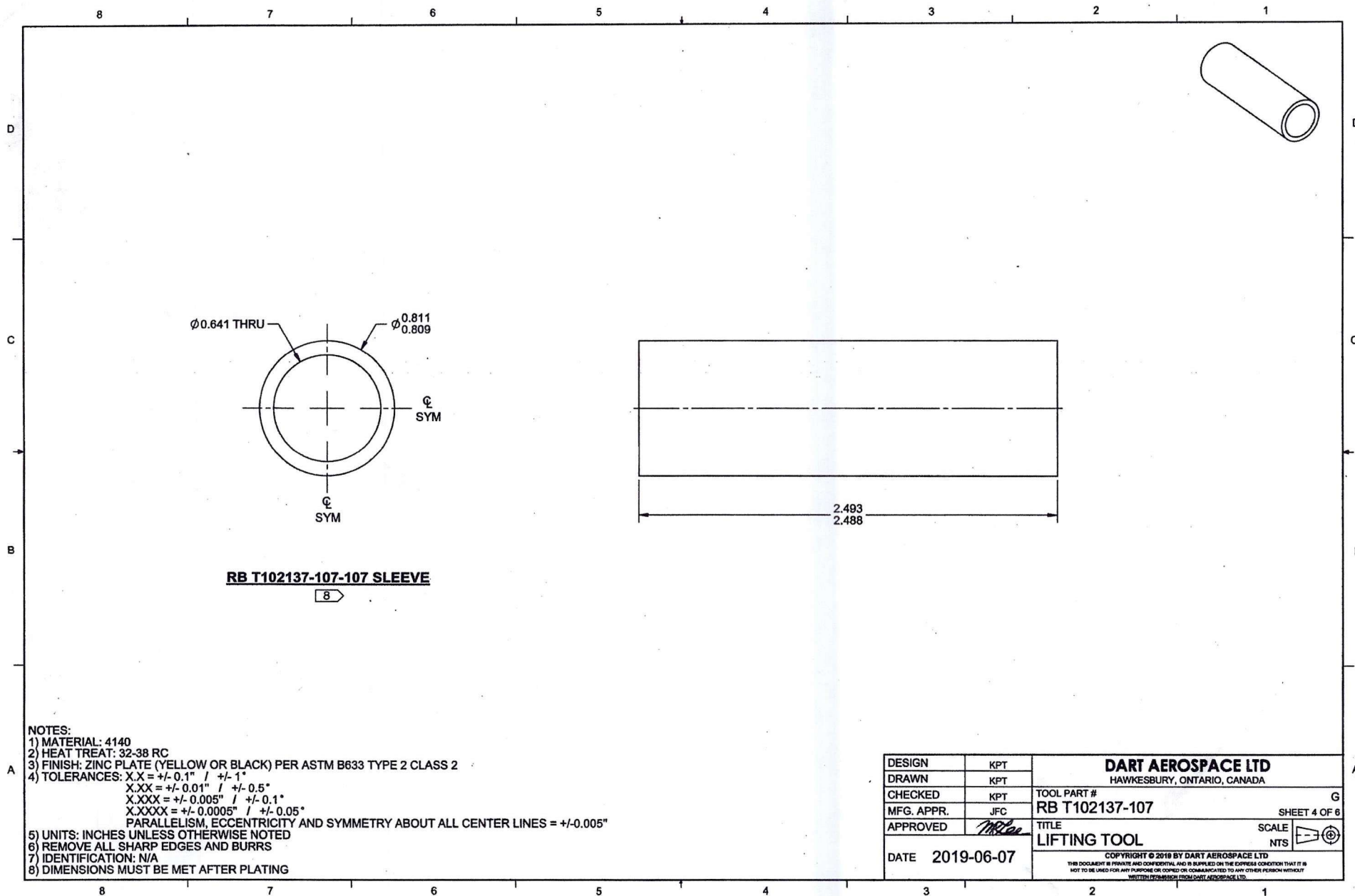
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
134 QC 6	10 pcs	6/20/19	0.00 0.00	QC 6 - 9	DAS 61 9-80
				QC 6 - 68	
				QC 6 - 61	
				QC 6 - 40	
140 Packaging 3-1 - Stock - B4B	10 pcs	6/20/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	MLL
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	DAS
150 QC 21 - SA	10 pcs	6/20/19	0.00 0.00	QC 21 - SA - 21	21 JUL 04 2019 GA150
				QC 21 - SA - 70	9-85
				QC 21 - SA - 53	

Part Op 110 - MORI SL-154 LATHE - 1-Machine as per folio FB845 FOLIO REV: AA DWG REV: G 2-
 Descriptions: Deburr
 120 - QC2- Inspect parts off machine FAI/FAIB
 130 - QC8- Inspect parts - second check
 131 - QC5- Inspect part completeness to step on W/O
 132 - 1-Issue P/O; 43730 Heat treat RC 32-38 2-Bead blast 3-Material type; 4140 4-Certificate of Conformity is required
 133 - Receive & Inspect for Damage & Mat'l Certs
 134 - QC6- All purchased or subcontracted products ***NOTE*** Zinc plating to be done after load test at final assembly.
 140 - Identify as per dwg & Stock Location: _____
 150 - Identify as per dwg & Stock Location: _____

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M4140N-R0.875	4140 Steel Round Bar 0.875"	2.2500 ft (.225 ea)	110-SL-154 - 1	S044297

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-SL-154 - 1	M4140N-R0.875	2	20	0

Part Specifications	
Specifications could not be found.	



Dart Aerospace Ltd.
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Tel (613) 632-5200

PURCHASE ORDER

POHB043730



Supplier: MEI001-VC
Metcor Inc.
560 Boul. Arthur Sauve
Saint-Eustache
QC
J7R 5A8 Canada
Phone: 450 473 1884
Fax: 450 491 5498

PO No: POHB043730

PO Date: 6/14/19

Due Date: 7/5/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact:

Guerin, Kimberley
kguerin@dartaero.com

Attention: Bejenaru, Livia

Via: Ground

Pymt Terms: Net 30

Freight Terms:

Special Comments:

E-MAILED
2019-06-14

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	196159	RB T102137-107-109	Clevis 1-Issue P/O; Heat treat RC 32-38 2-Bead blast 3-Material type; 4140 4-Certificate of Conformity is required	Firmed - X6		7/5/19	6 pcs	0 pcs	6 pcs	\$51.666/pcs	\$310.00
2	196135	RBE1X36-176-779-1	Sleeve (Outsource process - Heat Treat) 1-Issue P/O; P/O RC 48-52 Material; O1 2-Bead blast 3- Certificate of Conformity is required	Firmed -		7/5/19	3 pcs	0 pcs	3 pcs	\$103.333/pcs	\$310.00
3	196201	RB T102137-107-105	Strap 1-Issue P/O; RC 48-52 2-Bead blast 3-Material type; O1 4- Certificate of Conformity is required	Firmed -		7/5/19	10 pcs	0 pcs	10 pcs	\$31.00/pcs	\$310.00



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PURCHASE ORDER

POHB043730



Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
4	196200	RB T102137- 107-107	Sleeve 1-Issue P/O; Heat treat RC 32-38 2-Bead blast 3-Material type; 4140 4-Certificate of Conformity is required	Firmed - X10	-	7/5/19 JUL 03 2019	10 pcs	0 pcs	10 pcs	\$31.00/pcs	\$310.00
5	194688	RBA8100- 80902-1	Wrench 1-Issue P/O to METCORE; P/O RC 35-40 2-Bead blast 3-Material type; 4140 4- Certificate of Conformity is required	Firmed - 7 X	-	7/5/19 JUN 28 2019	7 pcs	0 pcs	7 pcs	\$44.2857/pcs	\$310.00
Grand Total:											\$1,549.99

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 6/19/19 8:10 AM Dart.Guerin.Kimberley

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ
ST-EUSTACHE, QC J7R 5A8
Tel: 450-473-1884 / Fax: 450-491-5498

Reçu de livraison

Delivery Receipt

BON DE TRAVAIL Order	EXPÉDITEUR Shipper ID	BON D'EXPÉDITION Shipper
337395	1	138308

EXPÉDITION COMPLÈTE / Shipped Complete

CLIENT /Customer 215

DART AEROSPACE

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
Ph: 613-632-5200
Fax: 613-632-1053



LIVRÉ À /Shipped To

DART AEROSPACE

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
Ph: 613-632-5200
Fax: 613-632-1053

COMMANDE DU CLIENT Customer PO	BON DE LIVRAISON DU CLIENT Customer Shipper No.	TYPE DE MATÉRIEL Material Type	DATE DE LA COMMANDE Order Date	TRANSPORTEUR Carrier
HB043730		4140	2019/6/17	client

QUANTITÉ Quantity	No. PIÈCE / Part No.	NOM DE LA PIÈCE / Part Name	DESCRIPTION DE LA PIÈCE Part Description	POIDS Weight
16	RBT102137-107-107			27,
	(10) RBT102137-107-107	JOB 196200		
	(6) RBT102137-107-109	JOB 196159		

2 BOITE DE CARTON

TYPE DE CONTENEUR Container Type	# DE CONTENEURS # Of Containers	COMMENTAIRES CONTENEUR Container Comments
BOITE DE CARTON	2	

CERTIFICAT

EXPÉDIÉ PAR: Shipped by:	
-----------------------------	--

QUANTITÉ EXPÉDIÉE / Quantity Shipped: 16
POIDS EXPÉDIÉ / Weight Shipped: 27,00
QUANTITÉ RESTANTE / Quantity Remaining: 0
POIDS RESTANT / Weight Remaining: 0,00

RECEIVED
JUL 03 2019
DART AEROSPACE LTD.

APPROUVÉ
[Signature]

CERTIFICAT

QUANTITÉ EXPÉDIÉE / Quantity Shipped:	16
POIDS EXPÉDIÉ / Weight Shipped:	27,00

Signature:

Date:

EXPÉDIÉ LE / Shipped On : 2019/06/28

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél.: 450-473-1884

Télécopieur / Fax administration: 450-491-5498

Télécopieur / Fax production: 450 491-6454

Certificat de Conformité Détaillé

Detailed Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
337395	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

1

COMMANDE DU CLIENT customer po	CLASSIFICATION PIECE part classification	MATÉRIEL material	MAÎTRE D'OEUVRE prime contractor	PROGRAM
HB043730	N/A	4140		
SPÉCIFICATIONS DU PROCÉDÉ processing specifications				
SEL HARDEN				
HARDEN AND TEMPER				
EXIGENCE / requirement	SPÉCIFICATIONS / specified		TESTS EXÉCUTÉS / performed	RÉSULTATS DE TESTS / results
HARDNESS	32 - 38 HRC		16	35 - 37 HRC
			(916) DURETÉ MESURÉ 77,7 - 78,8 HR15N	
QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description		
16	27	RBT102137-107-107		
		(10) RBT102137-107-107 JOB 196200		
		(6) RBT102137-107-109 JOB 196159		
		2 BOITE DE CARTON		

DAS
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9-89

COMMENTAIRES / comments

SALT HARDEN 1550°F - 50 MINS

SNAP TEMPER 400°F - 2:00 HRS

TEMPER 1000°F - 3:00 HRS

RETEMPER 1025°F - 3:00 HRS

RETEMPER 1100°F - 3:00 HRS

GLASS BEAD

Heat treatment (HT) was performed with equipment that meets the requirements of requested specification.

All HT operations were performed in compliance with the required HT specification and all verifications have been performed and documented. No unauthorized changes were performed in regards to the HT. We certify that the material was manufactured, sampled, tested and inspected in accordance with the material specification and the purchase order and was found to meet the requirements.

This document and any attached documents may contain confidential or proprietary information and may be subject to export control laws and regulations. If you are not the intended recipient, you are notified that any dissemination, copying of this e-mail and any attachments thereto or use of their contents by any means whatsoever is strictly prohibited. Unauthorized export or re-export is prohibited.

Le traitement thermique (TT) a été fait en utilisant des équipements en conformité avec la spécification demandée.

Toutes les opérations de TT ont été faites en conformité avec les requis de la spécification demandée et toutes les

vérifications et les tests demandés ont été faites et documentés. Aucun changement n'a été faite par rapport au TT. On

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél.: 450-473-1884

Télécopieur / Fax administration: 450-491-5498

Télécopieur / Fax production: 450 491-6454

Certificat de Conformité Détaillé

Detailed Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
337395	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

1

certifie que le matériel a été fabriqué, échantillonné, testé et inspecté en accord avec les spécifications du matériel et le bon de commande et le matériel rencontre les exigences spécifiées.

Ce document et les documents qui lui sont joints peuvent contenir des informations confidentielles, être soumis aux réglementations relatives au contrôle des exportations ou ayant un caractère privé. S'ils ne vous sont pas destinés, nous vous signalons qu'il est strictement interdit de les divulguer, de les reproduire ou d'en utiliser de quelque manière que ce soit le contenu. Toute exportation ou réexportation non autorisée est interdite.

APPROUVÉ par / Approved by:



DATE: 2019-06-28

Lucie Desmarais
QA Technician



METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél.: 450-473-1884

Télécopieur / Fax administration: 450-491-5498

Télécopieur / Fax production: 450 491-6454

Certificat de Conformité

Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
337395	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

1

COMMANDE DU CLIENT customer po	CLASSIFICATION PIECE part classification	MATÉRIEL material	MAÎTRE D'OEUVRE prime contractor	PROGRAM
HB043730	N/A	4140		

SPÉCIFICATIONS DU PROCÉDÉ

processing specifications

SEL HARDEN

HARDEN AND TEMPER

EXIGENCE / requirement	SPÉCIFICATIONS / specified	TESTS EXÉCUTÉS / performed	RÉSULTATS DE TESTS / results
HARDNESS	32 - 38 HRC	18	35 - 37 HRC (916) DURETÉ MESURÉ 77,7 - 78,8 HR15N

QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description
18	27	RBT102137-107-107 (10) RBT102137-107-107 JOB 196200 (8) RBT102137-107-109 JOB 196159 2 BOITE DE CARTON

DAS
61
9-89

COMMENTAIRES / comments

APPROUVÉ par / Approved by:

DATE: 2019-06-28

Pierre Piché
Chief Inspector

METCOR
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APPROUVÉ